

Date: Monday, 11/14/2005 2:39:40 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206 L HIGH GEAR SKIDTUBE
Job Number	: 24738		
Estimate Number	: 10522		
P.O. Number	: N/A	Part Number	: D206642441
This Issue	: 11/14/2005	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2650 REV D1
First Issue	: N/A	Project Number	: N/A
Previous Run	: 24739	Drawing Revision	: D1
	Type : LANDING GEAR	Material	: N/A
Written By	: SEE COMMENT BELOW	Due Date	: 11/30/2005
Checked & Approved By	: SEE ABOVE USER & DATE	Qty:	1
Comment	: Est Rev: H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM		

Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-441CHG002

D.H
Rec'd paper work 06/03/09

2.0	D2620	Bent 206 Skidtube
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2620	Bent Tube 3" OD	B24497 DP 05-12-1

3.0	D2647	Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2647	Fwd Cap	B20535 BE 05-12-1

4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R Aluminum Rod M18901 BE 05-12-1

4-Grind weld flush to cap on top surface only.

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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5-Cut aft end 138.60" from front of tube *BE 05-12-1*

6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312". *BE 05-12-1*

7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297". *BE 05-12-1*

8-Open using #6 Drill Bit *BE 05-12-1*
Ø0.625" & est. updated 05.12.01

9-Open holes for Tow Ring to *Ø0.640"* as per Dwg D2650, D2650-7 Drilling Detail *BE 05-12-1*

10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2650

11-Deburr and Blow out all chips form inside the tube

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

05-12-05 A.M

6.0

D26547

206 I Beam (Web)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2654-7

Web

B24770 A.m 05-12-07

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail (without cutting fluid) *DP 05-12-7*

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid) *DP 05-12-7*

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer. *DP 05-12-7*

4-Bond D2654-7 web in place as per QSI 015Ensure holes line upAllow 12 Hrs. cure time before cutting

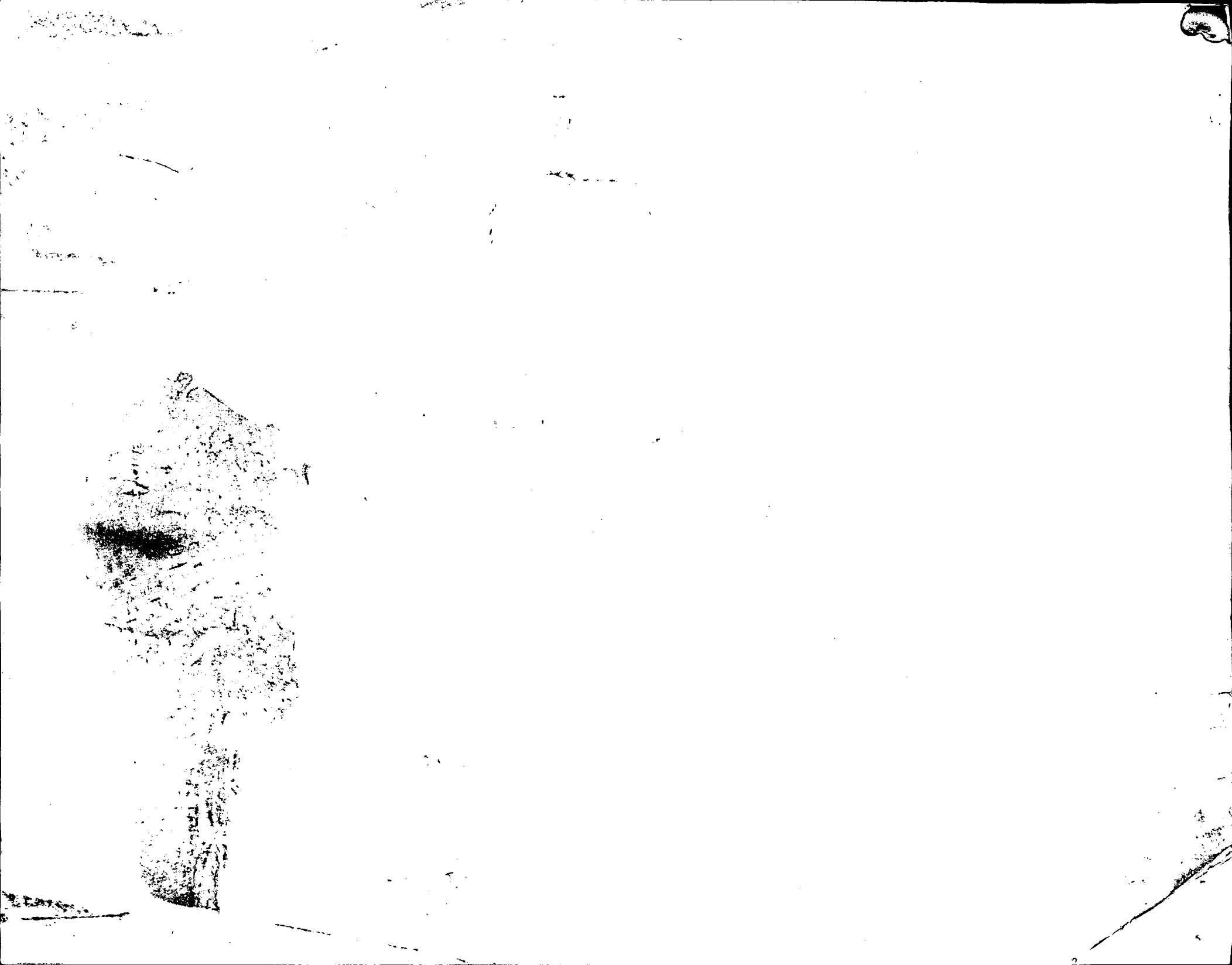
Start Date: *05-12-07* Time: *11:30*

Finish Date: *05-12-12* Time: *1:00*

A/R Sikaflex-291 *M18467*

Sikaflex expiry date: *05-12-31*

A.M 05-12-08



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Part Number: D206642441

Job Number:



Seq. #: Machine Or Operation: Description :

8.0

QC5

INSPECT WORK TO CURRENT STEP



05-12-08

Comment: INSPECT WORK TO CURRENT STEP

9.0

D2649

Crossbolt Spacer



Comment: Qty.: 23.0000 Each(s)/Unit Total: 23.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

23 D2649

Crossbolt spacer

B24200

BE 05-12-12

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

A/R Aluminum Rod *M15855*

BE 05-12-12

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube

BE 05-12-13

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650Debur

DP 05-12-13

11.0

D2682041

Support Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2680-041

Nut Plate

B21103

DP 05-12-14

12.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 CCR264SS3-3

Rivets

M18548

DP 05-12-14

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Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

M7885343

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 M7885/3-4-3

Rivets

MT808 DP05-12-14

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

DP05-12-14

15.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

11/05/14/14 DP05-12-14

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White (Ref. 4.3.5.1) as per QSI 005 4.3 *a.m 06-03-01*

Make sure Nut Plate Thread protected use paint screw

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 03 02

18.0

D26483

Wearpad



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description Batch

6 D2648-3

Wearpad

52-1843

FC 06 03 02

19.0

D265615

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-15

Wearshoe

521712

FC 06 03 02

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Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D265623

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-23

Wearshoe

022085

Lot

FC

21.0

D265637

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-37

Wearshoe

02358

Lot

FC

22.0

D34291

WEARPAD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3429-1

Wearpad

024417

Lot

FC

23.0

ALS41032130

Insert



Comment: Qty.: 60.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 ALS4-1032-130

Inserts

018293

or (see QSI 017)

Lot

FC

24.0

AN960JD10L

Washer



Comment: Qty.: 60.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 AN960JD10L

Washer

012185

FC 06 03 02

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Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

MS27039108

Screw



Comment: Qty.: 60.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 MS27039-1-08

Screw

~~n16941~~

FC

26.0

D26511

Plug



Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick:

Qty Part Number

Description Batch

22 D2651-1

Plugs

025010

FC

27.0

D26513

O-Ring



Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick:

Qty Part Number

Description Batch

22 D2651-3

O-Rings

023491

FC

28.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 AN960JD416

Washer

n1151

FC

29.0

MS27039406

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 MS27039-4-06

Screw

n6874

FC 06 03 02

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Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2646

Aft Cap 020208

FC

31.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 AN960JD10L

Washer 019185

FC

32.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 MS27039-1-08

Screw 016941

FC

33.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R Sikaflex-291

019597

Sikaflex expiry date:

06 18 06

FC

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

FC

4-Inspect for foreign object per QSI 024

FC

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R Sikaflex-291

019597

Sikaflex expiry date:

06 18 06

FC

6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4

Batch: 010037

FC

06 03 08

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Job Number: 24738

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

MM 06.03.08 *①*

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Package per PPP

REV. F

C 206103109 ①

36.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

①
206103113

Job Completion



U 06.03.10

00000000

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 10, 2005
07:04 am

Work Order No : 0024738
Project Name : *D206-642-441
Project For : WK547
Work Order Type : Main
Main WO Number :
House Part Number : *D206-642-441
Description : Replacement Skidtube
Manufactured : Yes
Amount Req'd : 1
Amount Done : 0
Start Date : 11-09-05
Est Finish Date : 11-24-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00